

**Work Order ID 59209**

Friday, May 28, 2010 9:22:06 AM



Page 1

Item ID: D3909-3

Accept



Setup Start



Revision ID:

Item Name: Fwd Lower Attach Arm

Stop



Start Date: 5/27/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 6/4/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan:



Date: 203-28

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D3909

B

100



Cut blanks as per folio

0.00

203 10/06/01

5 0

Bandsaw

Memo

0.00

Jeaspa Bandsaw

CUT BLANK 3.455" LONG

110



HAAS 1

HAAS CNC vertical machine #1

Memo

0.00

203 10/06/01

5 0

MACHINE AS PER FOLIO FA872 AND DWG

FOLIO REV: A

DWG REV: B

DEBURR

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Cust Item ID:

Required Date: 6/4/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

120



QC

Quality Control

Operation  
Description

QC2- Inspect parts off machine FAI/FAIB

Set Up/  
Run Hours

0.00

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp*and 10/06/01**5 0*

130



QC

Quality Control

QC8- Inspect parts - second check

0.00

*MW  
10/06/02**5 0*

160



Packaging

Packaging

Identify as per dwg & Stock Location: 95

0.00

Memo

0.00

*10-6-2 80*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 3

Item ID: D3909-3

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Stop



Start Date: 5/27/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 6/4/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
Description

170



QC21- Final Inspection - Work Order Release

QC

Quality Control

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

0.00

Memo

0.00

10/06/03

W W doB3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

# Picklist Print

Friday, May 28, 2010 9:22:12 AM

Page 1

Work Order ID: 59209



Parent Item: D3909-3



Parent Item Name: Fwd Lower Attach Arm

Start Date: 5/27/2010

Required Date: 6/4/2010

Comments: IPP REV:A NEW ISSUE 09-11-26 JLM VERIFIED BY:DD IPP  
Rev:B chg blank size in seq 100 DD 10.02.10 verified JLM IPP Rev:C as per  
dwg revB DD 10.04.20 verified by:EC

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ M303B0.750X1.500	Replacement	Mfg/ Purchased	Bin No	Primary	Last	Route 100	Unit of f	Qty on 1.8839	Qty per Kit 0.3333	Total 4.210105	Qty	Date	Status
303 BAR .750" X 1.500"													

Location	Loc Qty	Loc Code
MAT53	1.8839	
113310	1.8839	

1.8839 and 10/06/01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	59209
Description: Fwd Lower Attach Arm	Part Number:	D3909-3
Inspection Dwg: D3909	Rev: B	Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

Measured by:	<i>Arn</i>	Audited by:	<i>MW</i>	Preliminary Approval:	
Date:	10/06/01	Date:	10/06/01	Date:	

Rev	Date	Change	Revised by	Approved
A	10.04.20	New Issue	KJ	 

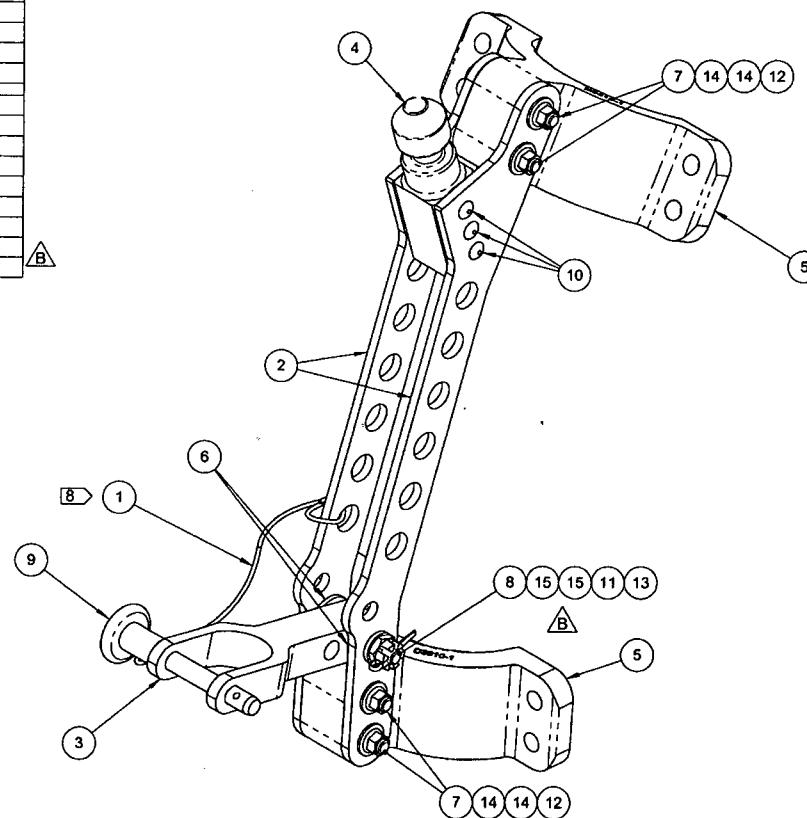
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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NOTE: Date & initial all entries

ITEM	QTY	P/N	DESCRIPTION
X	1	D3909-041	FWD X-TUBE LUG ASSY
1	1	D2690-6	LANYARD
2	2	D3909-1	FWD X-TUBE LUG PLATE
3	1	D3909-3	FWD LOWER ATTACH ARM
4	1	D3909-5	EYEBOLT STUD
5	2	D3910-1	X-TUBE LUG
6	2	D3917-1	WASHER
7	4	AN3C12A	BOLT
8	1	AN3C13	BOLT
9	1	MS17984-C413	PIP PIN
10	3	MS20615-4M20	RIVET
11	1	AN310C3	NUT - CASTELLATED
12	4	MS21043-3	NUT
13	1	MS24665-151	COTTER PIN
14	8	NAS1149C0332R	WASHER
15	2	NAS1149C0363R	WASHER



D3909-041 FWD X-TUBE LUG ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3909-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.74 lbs
- 8) ATTACH TO D3909-1 BY LOOPING AROUND LIGHTENING HOLE FIRST AND THEN SECURE TO MS17984-C413 PIP PIN'S RING

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 39209  
12/05/2012

RELEASED  
2010-04-07  
MP

B	BOM: ADDED ITEM 15 QTY 2 NAS1149C0363R ADDED, ITEM 14 QTY 8 WAS 10. SHT 5, D3909-5 REVISED; SECTION A-A & DIM Ø0.650 REMOVED. SIDE VIEW ADDED. DIM: 2.68 WAS 2.38 REF. 1.30 WAS 1.00, 0.250 WAS 0.220. R0.06 WAS R0.05. WEIGHT REVISED.			JPH	10.04.06
A	NEW ISSUE			JPH	10.03.04
REV.	DESCRIPTION	BY	DATE		
DESIGN	JPH			DART AEROSPACE LTD	
DRAWN	JPH			HAWKESBURY, ONTARIO, CANADA	
CHECKED				DRAWING NO.	REV. B
MFG. APPR.				D3909	SHEET 1 OF 5
APPROVED				TITLE	SCALE
DE APPR.				FWD X-TUBE LUG ASSY	NTS
DATE	10.04.06				

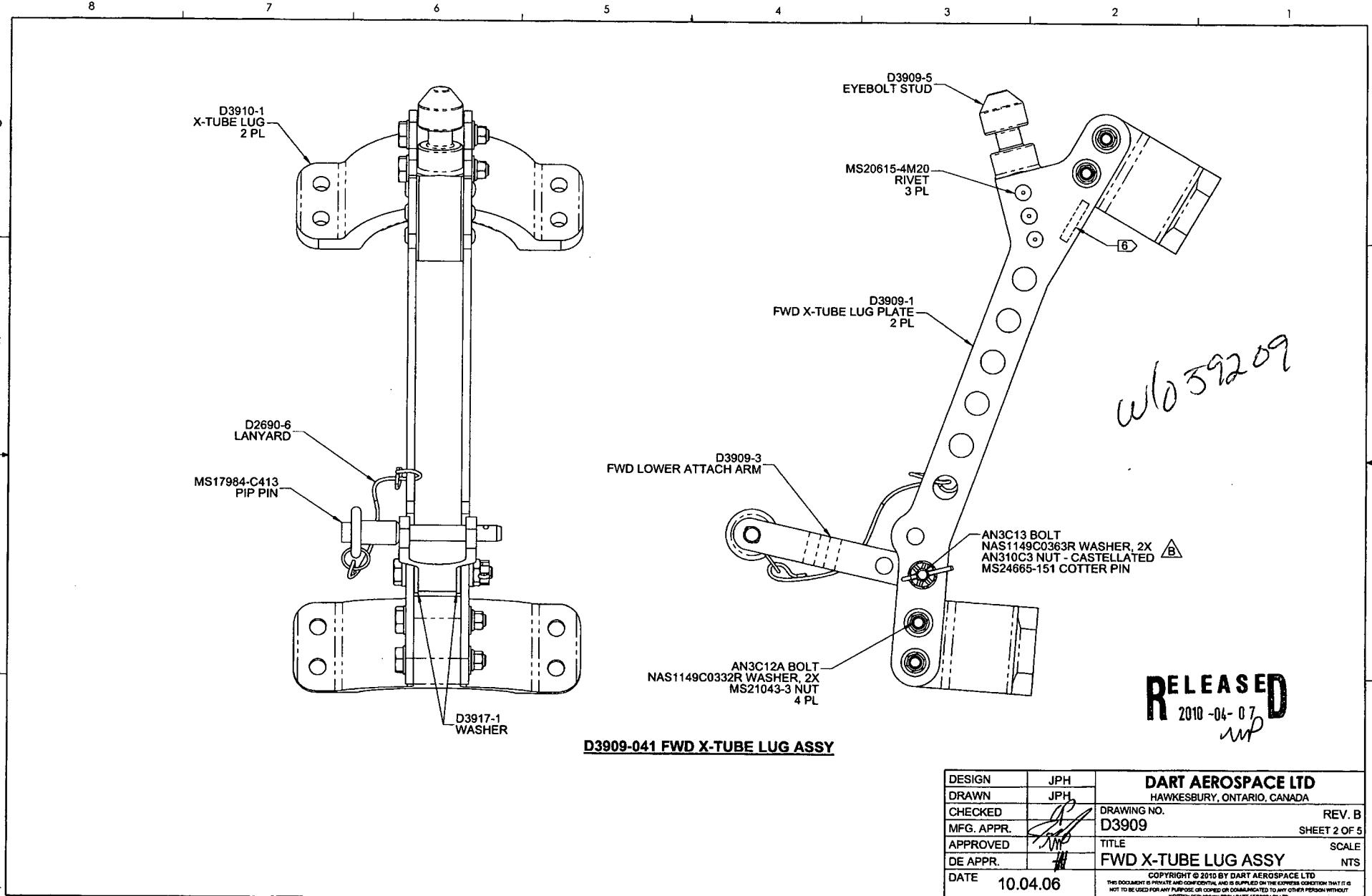
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W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



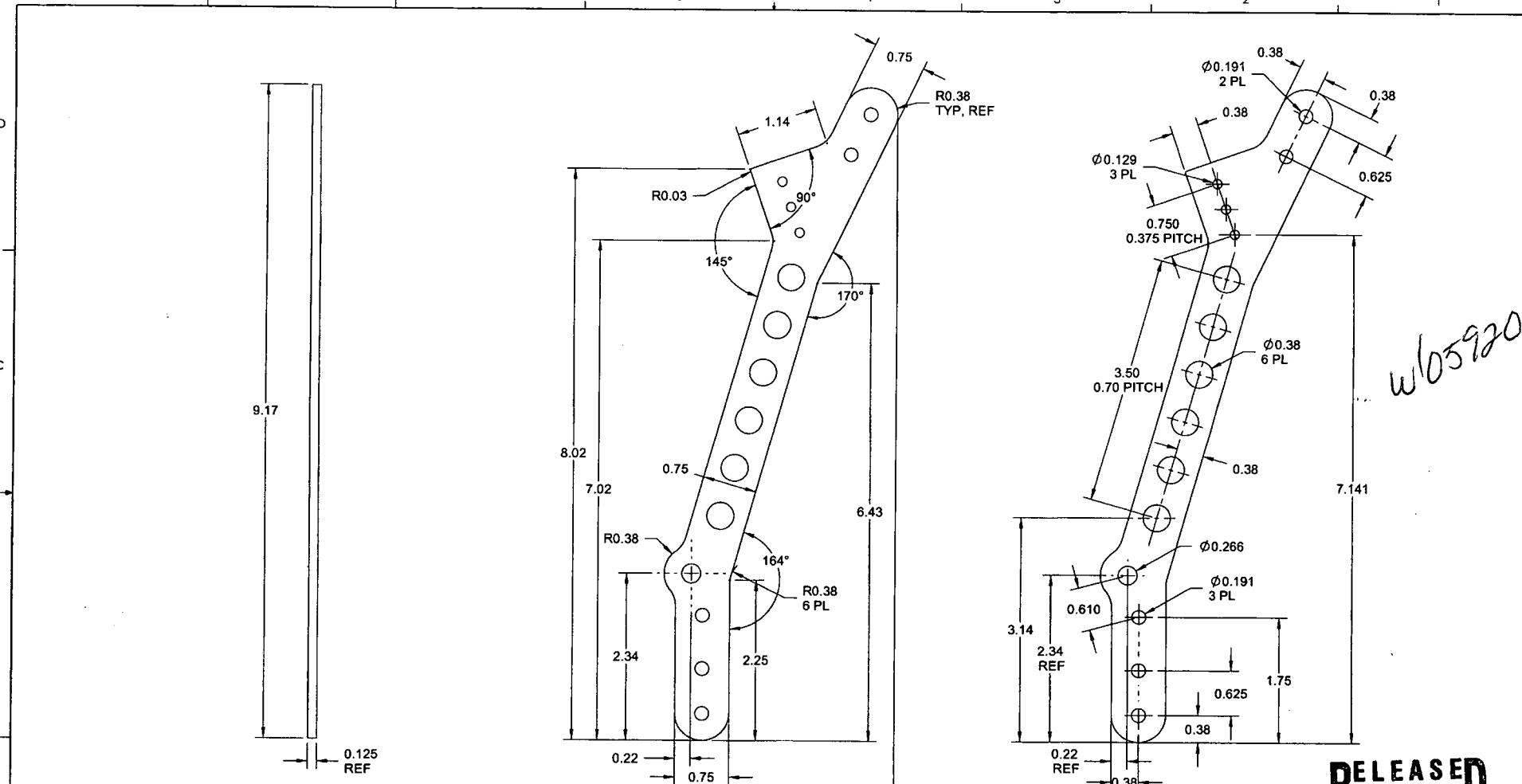
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



D3909-1 FWD X-TUBE LUG PLATE

(SUPPLEMENTAL VIEW)

RELEASED  
2010-04-07  
JW

## NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL 0.125" SHEET ANNEALED 2B, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 PER DART SPEC M303S11GA OR M304S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.25 lbs

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	
MFG. APPR.	<i>[Signature]</i>	D3909	REV. B
APPROVED	<i>[Signature]</i>	SHEET 3 OF 5	
DE APPR.	<i>[Signature]</i>	TITLE	SCALE
DATE	10.04.06	FWD X-TUBE LUG ASSY	NTS

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8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

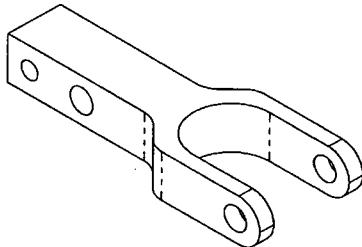
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

D

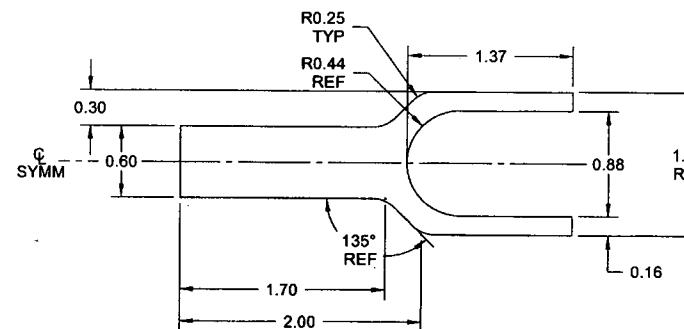
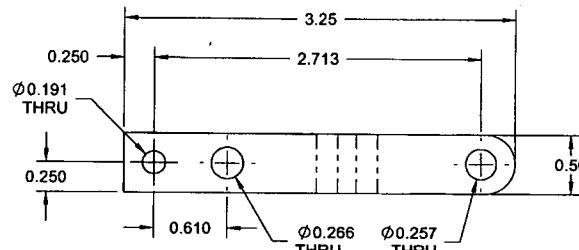


C

C

B

B



D3909-3 FWD LOWER ATTACH ARM

W10 39289

RELEASED  
2010-04-07  
MP

A

A

## NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276  
PER DART SPEC M303B OR M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.22 lbs

DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	JPH	
CHECKED		DRAWING NO. D3909
MFG. APPR.		REV. B SHEET 4 OF 5
APPROVED		TITLE FWD X-TUBE LUG ASSY
DE APPR.		SCALE NTS
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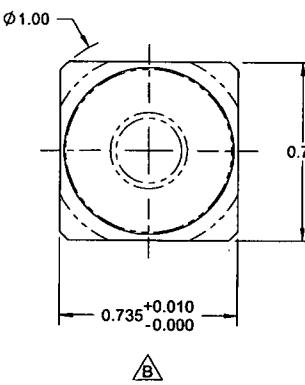
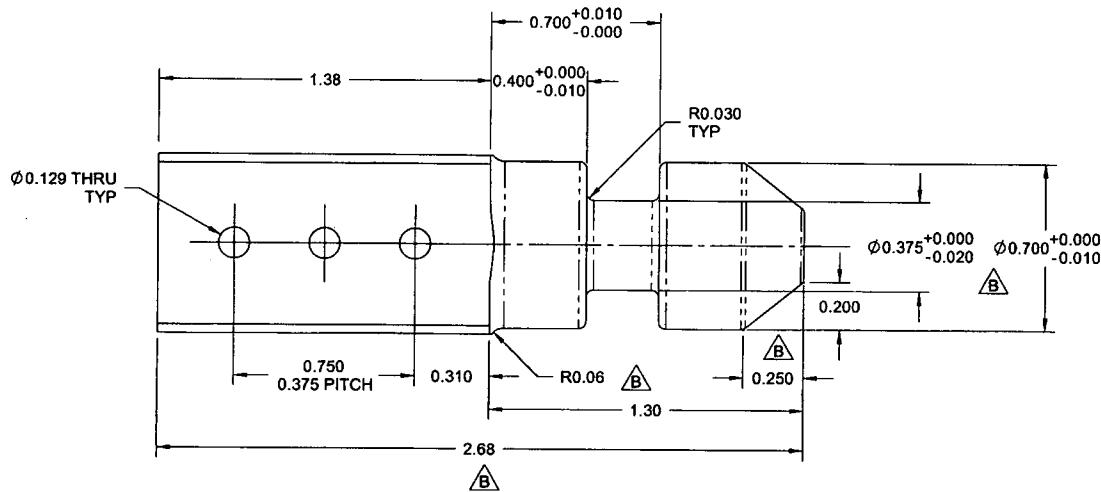
8 7 6 5 4 3 2 1

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



### **D3909-5 EYEBOLT STUD**

## NOTES.

**NOTES:**

- 1) MATERIAL: 303/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276  
PER DART SPEC M303R OR M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3909-5" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.31 lbs

RELEASED  
2010-04-07  
WMP

DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	JPH			
CHECKED	<i>CL</i>	DRAWING NO.	REV. B	
MFG. APPR.	<i>CL</i>	D3909	SHEET 5 OF 5	
APPROVED	<i>MW</i>	TITLE	SCALE	
DE APPR.	<i>CL</i>	FWD X-TUBE LUG ASSY	NTS	
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